

Work Order ID 98010

Friday, March 01, 2013 2:34:39 PM

98010March 5th 2013
Page 1

Item ID: D2749-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 3/1/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/14/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *B-3-4*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2749

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 11.25" long

MJP 13/03/07

4

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2749-7

MJP 13/03/07

4

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MJP 13/03/07

4

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Shy ASAP

98010

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Approvals:

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Tumble and Deburr

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

FD 13/03/08

4 0

W/AS

4 NB B-3-7

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Customer:

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Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC


Quality Control

QC3- Inspect part completeness to step on W/O

0.00

Memo

0.00

4. ϕ 13-3-11 

170

170

Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

11:10

OVEN TEMPERATURE:

225° FINISH TIME:

11:40.

4 ϕ 13-3-11.

180

180

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

DAS
27
13.3.11

4

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Page 4

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

4x

SP
13-3-11

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ

13-03-11

MF

13-3-11

Picklist Print

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Page 1

Work Order ID: 98010

Parent Item: D2749-7

Parent Item Name: Strut

Start Date: 3/1/2013

Required Date: 3/14/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.05.19Added inspection level 8, removed P/O for powder coatingEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.750 6061-T6 Bar .750 x .750		Purchased	No			100	f	17.5320	0.9375	3.9473684			

Location

MAT049

121836

124443

Loc Qty

17.532

5.532

12

Loc Code

121836 → 1,891
124443 → 1,891

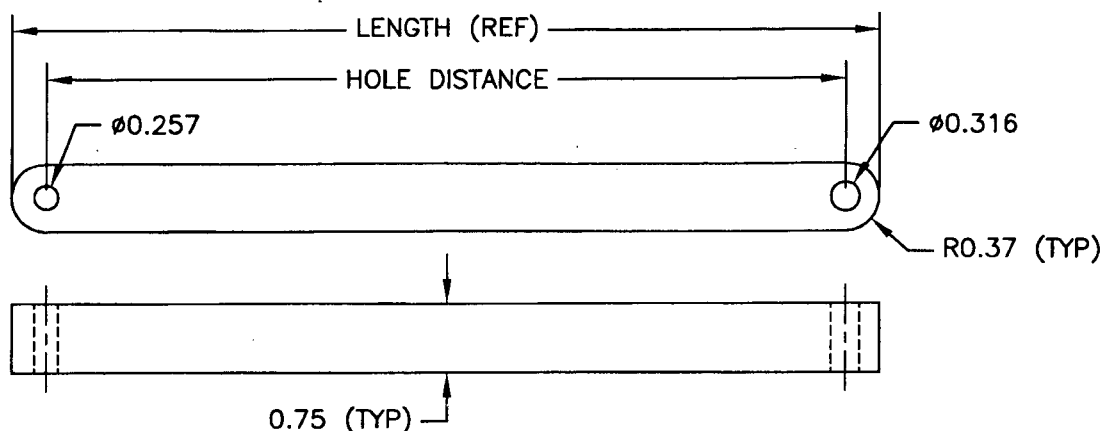
MVP 13/03/07

JP



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2749	REV. C SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	99.09.24	NEW ISSUE	
B	99.10.08	REMOVED LIGHTENING HOLES	
C	07.02.13	ADD D2749-9/-11	

RELEASED
07.02.14



DART P/N	HOLE DISTANCE	LENGTH (REF)
D2749-1	8.700	9.45
D2749-3	7.890	8.64
D2749-5	12.630	13.38
D2749-7	10.340	11.09
D2749-9	7.000	7.75
D2749-11	5.188	5.94

D2749-1/-3/-5/-7/-9/-11 STRUT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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